

Work Order ID 68641

Tuesday, April 19, 2011 12:49:21 PM



Page 1

Item ID: D412-742-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Float Skidtube Installation

Start Date: 4/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-04-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-742

D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-742-013 CHG006

8/11/04/16for CL 11-6-8

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/66/08

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/11/04/1611/66/081368646

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68641

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Page 2

Item ID: D412-742-013

Accept

Setup Start

Revision ID:

Stop

Item Name: Float Skidtube Installation

Start Date: 4/19/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-742-013
Location: _____

Rec'd

4/19/11

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

4/20/11

ME
11-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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1. The first step in the process is to identify the problem. This involves gathering information about the situation and the people involved.

2. The second step is to analyze the problem. This involves breaking the problem down into smaller parts and understanding the causes and effects.

3. The third step is to develop a plan. This involves deciding on the best way to solve the problem and setting goals and objectives.

4. The fourth step is to implement the plan. This involves putting the plan into action and making any necessary adjustments.

5. The fifth step is to evaluate the results. This involves checking to see if the problem has been solved and if the goals and objectives have been met.

6. The sixth step is to document the process. This involves writing down what was done and how it was done, so that it can be repeated in the future.

7. The seventh step is to share the results. This involves telling others about what was done and how it was done, so that they can learn from the experience.

8. The eighth step is to review the process. This involves looking back at what was done and thinking about what could be done better next time.

9. The ninth step is to celebrate the success. This involves acknowledging the hard work and effort that went into solving the problem.

10. The tenth step is to continue to improve. This involves looking for ways to make the process even better and more efficient.

[illegible]

Required Qty: 1.00

Comments: IPP Rev: A 05.10.13 New Issue KJ/JLM
IPP Rev:B 06-06-08 As per DS19336 JLM IPP RevC 07-12-03 ECN
1072 DD verified by:JLM
IPP Rev:D 08-09-08 ecn 08-510 DD verified by:EC
IPP Rev:E 09-01-23 as per DS19441 DD verified by:EC IPP RevF: add
AN4C7A DD 10.01.13 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C7A 		Purchased	No			110	Each	427.0000	4	4			
Bolt													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST356			427						
					109147		427			109147			
D412-742-043 		Manufactured	No			110	Each	0.0000	1	1			
Replacement Float Skidtube													
D2571 		Manufactured	No			110	Each	8.0000	1	.1			
Saddle, Fwd Out 205													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST433			8						
					63499		8						
D2572 		Manufactured	No			110	Each	5.0000	1				
Saddle, Fwd In 205													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST433			5						
					63500		5						

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

Work Order ID: 68641

Parent Item: D412-742-013


Parent Item Name: Float Skidtube Installation

Start Date: 4/19/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

D2573

Saddle, Aft Out 205

Manufactured No

110 Each

4.0000

1



1
69687

[Handwritten signature]

Location

Loc Qty

Loc Code

ST434

4

63501

4

110 Each


4.0000

1



1
69688

[Handwritten signature]

D2574

Saddle, Aft In 205

Manufactured No

Location

Loc Qty

Loc Code

ST434

4

63502

4

110 Each

92.0000


2



2

JB

[Handwritten signature]

D2876

Saddle Spacer

Manufactured No

Location

Loc Qty

Loc Code

ST025

92

66849

44

ST026

48

68282

48

110 Each

111.0000

2



68282
2 ✓

JB 11/06/08

D2877

Saddle Spacer

Manufactured No

Location

Loc Qty

Loc Code

ST025

111

63325

11

66843

40

68283

60

68283

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 68641

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 4/19/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3403-1

Manufactured No

110

Each

40.0000

16

16 ✓



Bushing



69508 JB

[Signature]

Location

Loc Qty

Loc Code

ST052

40

63316

40

D2747

Manufactured No

110

Each

110.0000

4

4 ✓



Set Screw



JB

[Signature]

Location

Loc Qty

Loc Code

ST021

110

62085

10

64276

100

D3533-1

Manufactured No

110

Each

126.0000

2

12 ✓



Set Screw



64276

JB 11/06/08

Location

Loc Qty

Loc Code

ST066

126

66138

26

67583

100

67583

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 68641

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 4/19/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

AN4C6A

Purchased

No

110

Each

344.0000

16

'16

Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST306

50

117313

50

ST356

290

115016

14

116003

126

116400

50

116704

100

AN4C52A

Purchased

No

110

Each

104.0000

8

BOLT

Location

Loc Qty

Loc Code

ST361

104

113121

4

114784

40

117163

60

AN6C12A

Purchased

No

110

Each

74.0000

8

'8

BOLT

Location

Loc Qty

Loc Code

ST342

74

114442

24

116022

30

117366

20

116704

8

117619X6 JB

117688X2

117698

11/06/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 68641

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 4/19/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-3 Manufactured No
Phenolic Washer

110 Each 967.0000 32 32



JB

Location Loc Qty Loc Code

ST074 967

64176 967

110 Each 8.0000 32



64176

32

116900

JB

Location Loc Qty Loc Code

ST350 8

112828 8

110 Each 440.0000 8



8

JB

Location Loc Qty Loc Code

ST074 440

35523 440

110 Each 100.0000 8



35523

8

JB

Location Loc Qty Loc Code

ST347 100

113064 100

110 Each 635.0000 16



113064

16

JB 11/06/08

Location Loc Qty Loc Code

ST074 635

58046 635

58046

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 68641

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 4/19/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-4,

Purchased

No

110

Each

1,180.000

29

29



Nut



114784

JB

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

600

117423

600

ST301

540

114523

3

116188

237

116549

300

D3403-3

Manufactured

No

110

Each

50.0000

8

8. ✓



Bushing



68949X5

JB

69509X3

Location

Loc Qty

Loc Code

ST052

50

59598

9

62240

1

66846

40

D3405-041

Manufactured

No

110

Each

11.0000

1

1 ✓



Lug Assembly



68346

JB 4/06/08

Location

Loc Qty

Loc Code

ST474

11

62227

2

62958

9

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 68641

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 4/19/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3405-043

Manufactured No

110

Each

3.0000

1

1



Lug Assembly



68343

[Signature]

Location

Loc Qty

Loc Code

ST423

2

65703

2

ST474

1

62959

1

AN4C47A

Purchased

No

110

Each

91.0000

4

4



Bolt



JB *[Signature]*

Location

Loc Qty

Loc Code

ST361

91

115518

6

116003

20

116400

25

117163

40

116400

D3407-041

Manufactured

No

110

Each

4.0000

1

1



Tow Ring



68345 JB 11/06/08

Location

Loc Qty

Loc Code

ST464

4

62960

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 68641



Parent Item: D412-742-013



Parent Item Name: Float Skidtube Installation

Start Date: 4/19/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3417-3

Manufactured No

110

Each

112.0000

2

2

✓



Washer



JB

Location

Loc Qty

Loc Code

FG

9

33519

9

ST053

103

44349

22

51648

28

53182

23

66847

30

~~44349~~

66847 x2

D3456-1

Manufactured No

110

Each

23.0000

1

1



Washer



69774 JB

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

16

66848

16

AN3C37A

Purchased No

110

Each

129.0000

1

1



BOLT



JB 11/06/08

Location

Loc Qty

Loc Code

ST353

29

116874

11

117010

18

ST354

100

117343

100

117343

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 9

Work Order ID: 68641

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 4/19/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C40A

Purchased

No

110

Each

103.0000

1

1



BOLT

Location

Loc Qty

Loc Code

ST354

103

106176

3

112454

50

114442

50

112454

AN3C41A

Purchased

No

110

Each

152.0000

1

1



BOLT

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

148

116381

8

117163

60

117407

80

117163

AN3C42A

Purchased

No

110

Each

52.0000

1

1



BOLT

Location

Loc Qty

Loc Code

ST354

52

106176

52

106176

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 68641

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 4/19/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C43A

Purchased

No

110

Each

88.0000

4

4



BOLT



JB

[Handwritten signature]

Location

Loc Qty

Loc Code

ST354

88

114433

28

114455

20

117313

40

117313
5.

AN3C46A

Purchased

No

110

Each

62.0000

5



BOLT



JB

[Handwritten signature]

Location

Loc Qty

Loc Code

FP-B

37

113302

37

ST355

25

115030

5

115518

20

113302

AN960C10L

NAS1149C0332
R

Purchased

No

110

Each

0.0000

26

26



washer

MS21043-3

Purchased

No

110

Each

948.0000

13

13



Nut



117460

JB

[Handwritten signature]

11/06/08

Location

Loc Qty

Loc Code

FG

80

103691

80

FP-B

-5

112314

-5

ST301

873

112314

873

112314

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

Item	Qty -013	Qty -043	Part Number	Description
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE
		1	D3391-043	412 FLOAT SKIDTUBE
1		*24	*AN3C4A	*BOLT
3		*12	*AN3C6A	*BOLT
4		*8	*AN3C7A	*BOLT
5		*44	*AN960C10L	*WASHER
21A		*1	*D3564-1	*WEARSHOE (REPLACES D3460-1)
21B		*1	*D3566-1	*GASKET
22A		*1	*D3564-3	*WEARSHOE (REPLACES D3460-3)
22B		*1	*D3566-1	*GASKET
23A		*1	*D3564-5	*WEARSHOE (REPLACES D2577-5)
23B		*1	*D3566-5	*GASKET
10		*1	*D3391-021	*412 FORWARD TUBE
11		**1	**D3401-041	**TOW CAP
12A		**10	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB166)
12B		**2	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB166)
13		**10	**AN3C4A	**BOLT
14A		**4	**D3672-1	**WASHER (REPLACES NAS1515H3L)
14B		**10	**AN960C10L	**WASHER
24A		**1	**D3564-13	**WEARSHOE
24B		**1	**D3566-13	**GASKET
20		*1	*D3391-023	*412 MID TUBE
28		**20	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB116)
30		*1	*D3391-025	*412 AFT TUBE
25A		**1	*D3537-1	**WEARPAD
25B		**1	*D3553-1	**GASKET
26A		**1	*D3537-7	**WEARPAD
26B		**1	*D3553-3	**GASKET
31		**1	**D2646	**AFT CAP
32		**14	**AELS-1032-130	**INSERT
36		**12	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB366)
37A		**6	**AN3C4A	**BOLT
37B		**4	**AN3C5A	**BOLT
38A		**2	**D3672-1	**WASHER (REPLACES NAS1515H3L)
38B		**10	**AN960C10L	**WASHER

(CONTINUED ON PAGE 19)

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Item	Qty -013	Qty -043	Part Number	Description
40	1		D2571	SADDLE, FWD OUTSIDE
41	1		D2572	SADDLE, FWD INSIDE
42	1		D2573	SADDLE, AFT OUTSIDE
43	1		D2574	SADDLE, AFT INSIDE
44	2		D2876	SADDLE SPACER
45	2		D2877	SADDLE SPACER
46	16		D3403-1	BUSHING
47A	4		D2747	SET SCREW
47B	2		D3533-1	SET SCREW
48	16		AN4C6A	BOLT
49	8		AN4C52A	BOLT
50	8		AN6C12A	BOLT
51A	32		D3672-3	WASHER (REPLACES NAS1515H4L)
51B	32		AN960C416L	WASHER
52A	8		D3672-9	WASHER (REPLACES NAS1515H6L)
52B	8		AN960C616L	WASHER
53	16		D3672-11	WASHER (REPLACES NAS1515H7L)
54	24		MS21043-4	NUT
55	4		ANC47A	BOLT
60	8		D3403-3	BUSHING
61	1		D3405-041	GHW LUG
62	1		D3405-043	GHW LUG
63	4		AN4C46A	BOLT
64	4		MS21043-4	NUT
70	1		D3407-041	TOW RING
71	2		D3417-3	WASHER
72	1		MS21043-4	NUT
73	1		D3456-1	WASHER
91	1		AN3C37A	BOLT
92	1		AN3C40A	BOLT
93	1		AN3C41A	BOLT
94	1		AN3C42A	BOLT
95	4		AN3C43A	BOLT
97	5		AN3C46A	BOLT
99	26		AN960C10L	WASHER
100	13		MS21043-3	NUT

*DENOTES PART IS INCLUDED WITH D3391-043 ASSEMBLY ABOVE

**DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: D

Date: 07.10.04

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. D AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 3.

REF. FAA STC: SR01583SE
REF. CANADIAN STC: SH05-37
REF. EASA STC: EASA.IM.R.S.01126

REFERENCE ONLY

INSTRUCTIONS:

- 1) FOR D412-742-011/-013 SKIDTUBES @ CHANGE 006 AND SUBSEQUENT, UPDATE THE PARTS LIST TO MODIFY THE BOLT USED TO ATTACH THE GHW LUG AS FOLLOWS:

5.1 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List

32.15 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List

ITEM	Qty -011	Qty -041	Qty -015	PART NUMBER	DESCRIPTION
	X			D412-742-011	FLOAT SKIDTUBE INSTALLATION
	1	X		D412-742-041	FLOAT SKIDTUBE
	1		X	D412-742-015	ELECTRIC STEP KIT

IS:

63	4			AN4C47A	BOLT
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WAS:

63	4			AN4C46A	BOLT
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5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

32.16 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

ITEM	Qty -013	Qty 043	PART NUMBER	DESCRIPTION
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE

IS:

63	4		AN4C47A	BOLT
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WAS:

63	4		AN4C46A	BOLT
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A	NEW ISSUE	AJS	08.12.19
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9441	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BOLT CHANGE	NTS
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